



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4149-1

Job Sheet 190580



Part No: D4149-1

Job Qty: 20 ea

Part Name: Crosstube Lug Plate, Aft



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/11/19

Job Tracking No:

Due Date: 2/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 11.03.03 as per revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		2/25/19	0.00	3.05	Waterjet - Flow		D4149-103106
110	QC	20 pcs		2/25/19	0.00	0.00	QC2 Waterjet-3		MAR 11 2019
120	QC	20 pcs		2/25/19	0.00	0.00	QC8-4		MAR 11 2019
150	Packaging	20 pcs		2/25/19	0.00	0.00	Packaging3		MAR 11 2019
160	QC21-SA	20 Ea		2/25/19	0.00	0.00	QC21		MAR 11 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	2.7100 sf (.1355 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	3	32	0

Part Specifications

Specifications could not be found.

Plex 2/11/19 1:09 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 190580
Description: Aft Crosstube Lug Plate		Part Number: D4149-1
Inspection Dwg: D4149	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø.130	1		V-Dura	
Ø0.191	+0.005/-0.001	Ø.193	1		Feeler	
Ø0.257	+0.006/-0.001	Ø.258	1			
Ø0.38	+0.006/-0.001	Ø.379	1			
0.380	+/-0.010	.383	1			
0.469	+/-0.010	.473	1			
0.310	+/-0.010	.313	1			
0.750	+/-0.010	.752	1			
3.25	+/-0.030	3.25	1			
0.65	+/-0.030	.65	1			
0.63	+/-0.030	.63	1			
5.46	+/-0.030	5.46	1			
3.80	+/-0.030	3.80	1			
2.13	+/-0.030	2.13	1			
1.313	+/-0.010	1.316	1			
0.625	+/-0.010	.627	1			
0.375	+/-0.010	.377	1			
1.175	+/-0.010	1.176	1			
0.752	+/-0.010	.753	1			
1.588	+/-0.010	1.589	1			
1.587	+/-0.010	1.589	1			
11.15	+/-0.030	11.15	1			
0.750	+/-0.010	.759	1			
1.55	+/-0.030	1.55	1			
1.12	+/-0.030	1.12	1			
8.42	+/-0.030	8.42	1			
2.70	+/-0.030	2.70	1			
0.125	+/-0.010	.117	1			
Ø0.252	+0.003/-0.000	Ø.253	1			

DAS
40

Measured by: De	Audited by: DAS 40	Preliminary Approval:
Date: 19/03/06	Date: MAR 11 2019	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	12.02.01	Dimensions updated per Dwg Rev C	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hewesbury, ON K0A 1K7
CANADA
TEL: 1 513 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S158315

Part: D4149-1

Job No: 190580

Serial No/Batch: S158315

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/01/19